

# Work Order ID 66419

Monday, February 14, 2011 11:45:49 AM

Page 1

Item ID: D2731-7

Accept

Revision ID:

Item Name: Mounting Lug

Start Date: 2/15/2011 Start Qty: 16.00

Required Date: 3/1/2011 Req'd Qty: 16.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: MF

Date: 11-02-14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2731

Rev C

0.00

0.00

Batch

0.00

0.00

BAND SAW

Memo

Cut D2423 extrusion to .82"

cut @ meter

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine as per folio FA930

DWG REV:

FOLIO REV:

issue Pro to meter PRO.13491

2-Check for crack while loading into the machine

machine as per drawing D2731 REV.C

CZ 11/02/14

CZ 11/02/14 16

100



Bandsaw

Jeaspa Bandsaw

110



HAAS 1

HAAS CNC vertical machine #1

Purchasing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 66419

Monday, February 14, 2011 11:45:50 AM



Page 2

Item ID: D2731-7

Accept



Setup Start



Revision ID:

Item Name: Mounting Lug

Stop



Start Date: 2/15/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 3/1/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120



QC  
Quality Control

~~QC2~~ Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

rec'd & inspect for transit damage + attached cufc to W/O.

10/11/3/10 18

130



QC  
Quality Control

~~QC2~~ Inspect parts - second check

0.00

Memo

0.00

ml 11 03 10 18

140



HandFinish  
Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

18 BR 11-3-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

[illegible]

Page 3

**Accept**

**Setup Start**

**Stop**

[illegible]**Cust Item ID:**

**Customer:**

**Reference:**

Run Start

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

**Stop**

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

### Operation Description

### Set Up/ Run Hours

**Tool ID****Tool #****Plan  
Code**

**Accept  
Qty**

Reject  
Qty

## Reject Number

**Insp.  
Stamp**

### Spray Painting per QSI005 4.2

0.00

[REDACTED]

## SprayPaint

## Memo

0.00

## Spray Painting

Prime Delfleet Blue : B 115967  
Paint Delfleet Blue : B 115985  
Clear Delfleet : B 117113

160



QC

### Quality Control

~~QCB~~- Inspect Part Finish

QC 14

0.00

## Memo

0.00

170

\_\_\_\_\_

### Packaging

## Packaging

Identify as per dwg & Stock Location: 720

0.00

## Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2731-7 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_





NCR: <u>66419</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11-03-17	145	product line of delFleet changing to lower vac's supplier misinformed & sent wrong clear	↓ 11/03/18	scuff & re-clean  update QSR 005 F3118 → F3921 1 to 1 1 to 1 mixture 3 part 50 1 part F3210 1/2 part F3330  ACCEPTABLE PER ATTACHED ENCL.	FF 11-03-17	↓ 11/03/18	↓ 11/03/18 QS1042	↓ 11/03/18



NOTE: Date & initial all entries


**Work Order ID 66419**

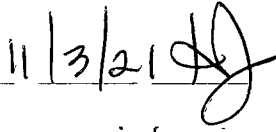
Page 4

Monday, February 14, 2011 11:45:50 AM

Item ID: D2731-7 Accept  Setup Start   
Revision ID: Stop   
Item Name: Mounting Lug  
Start Date: 2/15/2011 Start Qty: 16.00  Cust Item ID:  
Required Date: 3/1/2011 Req'd Qty: 16.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

11/3/21   
11-03-21  
(16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Monday, February 14, 2011 11:45:46 AM

Page 1

Work Order ID: 66419

Parent Item: D2731-7

Parent Item Name: Mounting Lug



Start Date: 2/15/2011

Required Date: 3/1/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP ☐ D ☐ 00.05.19 ☐ Added inspect level 8, removed P/O powder coating ☐ EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2423		Manufactured	No			110	f	507.6914	0.0683	1.150316			
-------	--	--------------	----	--	--	-----	---	----------	--------	----------	--	--	--



Lug Extrusion



CL 11/02/14

Location

Loc Qty

Loc Code

MAT06

507.6914265

43722

180

45800

39.6914265

63005

288

1.15

D2731-7P

Purchased

No

100

Each

0.0000

1

16



LUG



14/3/10 @ 18

# Dart Aerospace Ltd

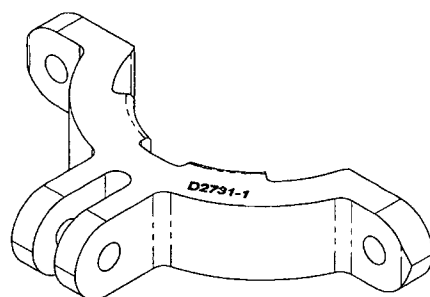
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

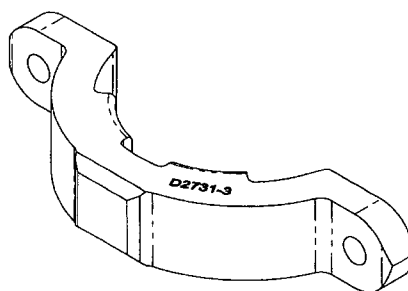
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

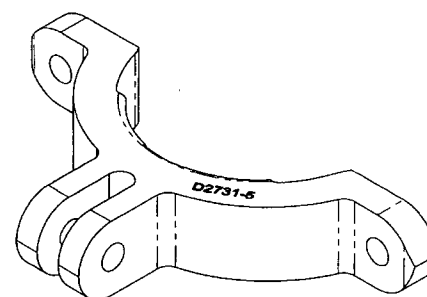
**NOTE:** Date & initial all entries



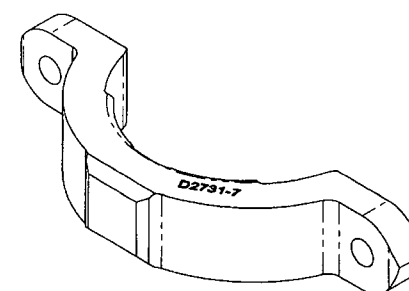
**D2731-1 MOUNTING LUG**



**D2731-3 MOUNTING LUG**



**D2731-5 MOUNTING LUG**



**D2731-7 MOUNTING LUG**

**RELEASED**  
09/01/19

**NOTES:**

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.17 lbs  
-3: 0.15 lbs  
-5: 0.16 lbs  
-7: 0.14 lbs

C	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A, B-B, C-C & D-D FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.19
B	REVISED DIMENSIONS	KE	99.07.06
A	NEW ISSUE	KE	98.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2731	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.19	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

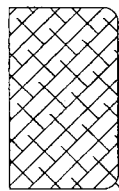
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

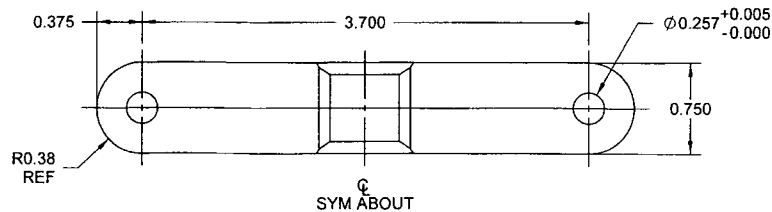
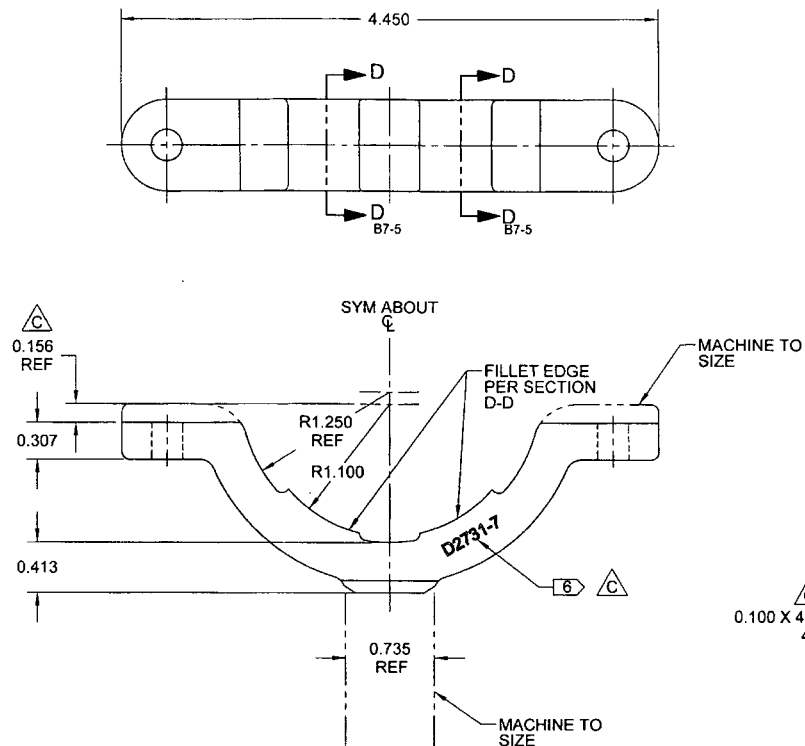
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**SECTION D-D** D4-5  
SCALE 2X



R0.06 MIN-R0.10 MAX  
2 PL



**D2731-7 MOUNTING LUG**

DESIGN	KE	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2731	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.19	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

#66419

**RELEASED**  
09/16/25

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

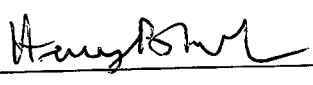
**NOTE:** Date & initial all entries

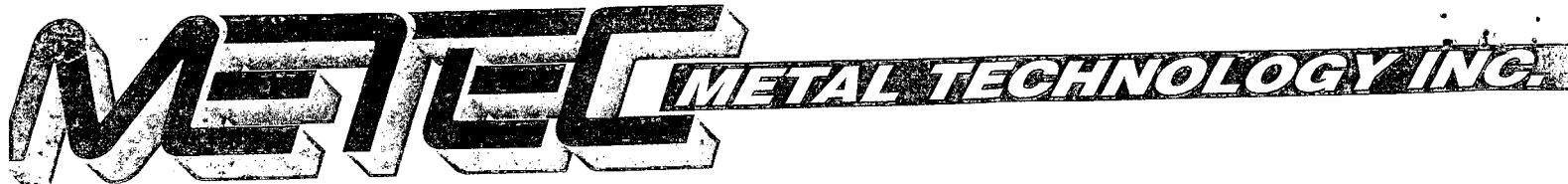


20 Terry Fox Drive  
Vankleek Hill, Ontario K0B 1R0  
Tel: (613) 678-3957  
Fax: (613) 678-3956

Delivery Slip No.: 17818  
Date: Mar 09, 2011  
Page: 1

<b>Sold to:</b>  <b>Dart Aerospace Ltd.</b> Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	<b>Ship to:</b>  Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
<b>Order No.:</b> 13491	<b>Sold By:</b>
<b>Shipped By:</b> your truck	<b>Ship Date:</b>

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2731-7 LUG Material supplied by DART: D2423 B45800 for 18 pieces D2423 B63005 for 32 pieces	Each	50 1	50 <u>18</u>	1
Received by <u></u>		Thank you for your order!		



## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
18	D2731-7	Lug MATERIAL: supplied by DART D2423 B45800	13491
32	D2731-7	Lug MATERIAL: supplied by DART D2423 B63005	13491

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Shigi Walz", is written over the printed name.

Shigi Walz

Vankleek Hill, March 9, 2011



## Linda Lacelle

---

**From:** David Shepherd <dshepherd@dartaero.com>  
**Sent:** March 18, 2011 11:14 AM  
**To:** 'Marc Bellavance'; 'Linda Lacelle'  
**Subject:** RE: D206-642-441B Skidtubes

Linda/Marc,

I was concerned that we had discovered a chemical incompatibility between the new paint and the clear and that is why we had to re-clear the skidtubes. Scuffing and re-clearing the skidtubes to a matte finish is acceptable to me.

David

**From:** Marc Bellavance [mailto:mbellavance@dartaero.com]  
**Sent:** Friday, March 18, 2011 9:04 AM  
**To:** 'Linda Lacelle'; 'Shepherd, David'  
**Subject:** RE: D206-642-441B Skidtubes

Linda, please call David, he has one or a few questions for you...

**From:** Linda Lacelle [mailto:llacelle@dartaero.com]  
**Sent:** March 18, 2011 9:32 AM  
**To:** 'Marc Bellavance'; 'Shepherd, David'  
**Subject:** RE: D206-642-441B Skidtubes

The skids were already scuffed, and the new clear was applied...these are suppose to ship today

**From:** Marc Bellavance [mailto:mbellavance@dartaero.com]  
**Sent:** March 18, 2011 9:25 AM  
**To:** Shepherd, David  
**Cc:** Lacelle, Linda  
**Subject:** D206-642-441B Skidtubes  
**Importance:** High

Good morning David,

Ian came to see me this morning re Delfleet product line changing to lower VOC's. The supplier was misinformed and sent us the wrong clear. Now the skidtubes must be scuffed and re-cleared. Also, this will affect QSI 005 since the mixture must be changed. A W/O NCR has been filled out by Ian on all the W/O's ( but we need your approval on this prior to signing off them off.

Call me if you have more questions, I'll answer with what I have and know about this issue.

Thanks,

**Marc Bellavance**  
**Technical/Shop Support**